

What is claimed is:

1. A cellulose ester film having a dry thickness of 20 to 60 μm , wherein the cellulose ester film is manufactured according to a solution cast film manufacture process comprising the steps of providing a cellulose ester dope, casting the cellulose ester dope on a support to form a cellulose ester web, peeling the cellulose ester web at a peel position from the support, transporting the peeled web to a dryer, drying the peeled web therein to form a cellulose ester film, and winding the cellulose ester film around a spool, the residual solvent content at the winding step of the cellulose ester film being not more than 0.05% by weight.

2. The cellulose ester film of claim 1, wherein the difference between the maximum residual solvent content and the minimum residual solvent content in the transverse direction of the cellulose ester film is not more than 0.02% by weight.

3. A cellulose ester film having a dry thickness of 20 to 60 μm , the cellulose ester film being manufactured according to a solution cast film manufacture process comprising the steps of providing a cellulose ester dope, casting the cellulose ester dope on a support to form a cellulose ester web, peeling the cellulose ester web at a

peel position from the support, transporting the peeled web to a dryer, drying the peeled web therein to form a cellulose ester film, and winding the cellulose ester film around a spool, wherein the peeled web is transported through a transport device from the peel position to a tension changing device nearest to the peel position at a tension of 10 to 100 N/m, the tension changing device being located between the peel position and the spool.

4. The cellulose ester film of claim 3, wherein the tension is 10 to 80 N/m.

5. The cellulose ester film of claim 3, wherein the tension is 10 to 50 N/m.

6. The cellulose ester film of claim 3, wherein the distance between the peel position and the tension changing device is 2 to 90 m in terms of the web length.

7. The cellulose ester film of claim 3, wherein the transport device uses guide rollers or an air float system.

8. The cellulose ester film of claim 7, wherein some or all of the guide rollers are tendency rollers.

9. A cellulose ester film having a dry thickness of 20 to 60 μm , the cellulose ester film being manufactured according to a solution cast film manufacture process comprising the steps of providing a cellulose ester dope,

casting the cellulose ester dope on a support to form a cellulose ester web, peeling the cellulose ester web at a peel position from the support, transporting the peeled web to a dryer, drying the peeled web therein to form a cellulose ester film, and winding the cellulose ester film around a spool, wherein the cellulose ester dope is provided by a method comprising the steps of a) mixing a cellulose ester and one or more solvents comprising an organic solvent with a boiling point BP ($^{\circ}\text{C}$) as the main organic solvent in a tightly sealed pressure resistant vessel and heating the resulting mixture to around BP, b) unsealing the vessel at that temperature to allow it to stand for not less than 6 minutes, re-sealing the vessel and further heating the mixture to a temperature of from BP to BP + 50 ($^{\circ}\text{C}$) to obtain a cellulose ester dope.

10. The cellulose ester film of claim 9, wherein the cellulose ester film contains no air bubbles with a size of not less than 0.3 μm .

11. The cellulose ester film of claim 9, wherein the method comprising the steps of after the re-sealing, c) further heating the mixture to a temperature of BP + 20 to BP + 50 ($^{\circ}\text{C}$) to be in a state of increased pressure, and d)

maintaining the resulting mixture at that pressure to obtain a cellulose ester dope.

12. The cellulose ester film of claim 11, wherein the cellulose ester film contains no air bubbles with a size of not less than 0.3 μm .

13. The cellulose ester film of claim 1, wherein the residual solvent content is not more than 0.04% by weight.

14. The cellulose ester film of claim 1, wherein the residual solvent content is not more than 0.02% by weight.